



Dart Aerospace Ltd.
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D4273-041
Job Sheet 202041



Part No: D4273-041

Job Qty: 1 pcs

Part Name: Basket Base Assembly, LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/18/19

Job Tracking No:

Due Date: 11/15/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4279 REV B SHEETS 1,2, D4273 REV F SHEETS 1,2,3,4,5 IPP Rev:A 10.11.16 new issue DD verf:EC
IPP Rev:B 11.01.20 AS PER DWG REV.C DD verf:EC IPP Rev:C 11.03.03 AS PER DWG REV.D DD verf:EC
IPP REV:D 12.07.24 AS PER DWG REV.E DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	11/15/19		0.00	66.67	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
110	QC 9	1 pcs	11/15/19		0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
120	QC 5	1 pcs	11/15/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		



Container No: S228934



Part: D4273 - 041

Job No: 202041

Serial No/Batch: S228934

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	EL
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
125 Handfinish - 2-1 Pressure-B4B	1 pcs	11/15/19	0.00	0.17		Handfinish - 2 - 1 - B4B	
						Handfinish - 2 - 2 - B4B	
						Handfinish - 2 - 3 - B4B	BL 19-11-01
						Handfinish - 2 - 4 - B4B	
130 Powdercoat - 2 White GI(S)-B4B	1 pcs	11/15/19	0.00	0.66		Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	BL 19-11-01
						Powdercoat - 3 - B4B	
						Powdercoat - 4 - B4B	
140 QC 3	1 pcs	11/15/19	0.00	0.00		QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	RL 19-11-01
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
150 Packaging 3-1 - Stock - B4B	1 pcs	11/15/19	0.00	0.00		Packaging 3 - 1 - B4B	RL 19-11-01
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	

DAS PA
15 5
9-89 83

					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
160 QC 21 - SA	1	11/15/19	0.00	0.00	QC 21 - SA - 21	NOV 04 2019
					QC 21 - SA - 70	Dag
					QC 21 - SA - 53	21

Part Op 100 - Large Fab 1 (Weld per dwg A/R S.S. rod Batch: _____) - 1- assemble ribs and handle plates (DO NOT WELD
 Descriptions: HANDLE IN SECTION E-E ON PAGE 2 DWG D4273, NEED TO WELDED AFTHET MESH IS INSTALL) weld as per dwg
 D4273 using DT10317 ***visual inspect before welding mesh*** 2- Cut D4279-1 base mesh (MADE ON THIS W/O) and
 tack weld all mesh on basket as per dwg D4273 and trim mesh to fit if necessary and trim to clear fasteners holes on the
 ends (D4279-5/-9)
 110 - QC9- Inspect visual per QSI004- Fusion Welds
 120 - QC5- Inspect part completeness to step on W/O
 125 - Pressure Wash per QSI005 4.3/ Clean and remove all markings
 130 - White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel - 1- Plug holes and mask only interior of hinge (3) prior to powder
 coat
 140 - QC3- Inspect Part Finish
 150 - Identify as per dwg & Stock Location: _____
 160 - QC21- Final Inspection - Work Order Release

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	100-Large Fab - Basket - 1	S211240
D3913-1	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	S210643
D3913-15	Wide Handle Plate	1 pcs (1 ea)	100-Large Fab - Basket - 1	S211077
D3913-3	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	S214906
D3913-9	Hinge Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	S214355
D3916-5	Light Rib	3 pcs (3 ea)	100-Large Fab - Basket - 1	S222730
D4016-1	Hinge Half, Base	3 pcs (3 ea)	100-Large Fab - Basket - 1	S213575
D4017-7	Rib	3 pcs (3 ea)	100-Large Fab - Basket - 1	S220292
D4021-1	Handle Plate	3 pcs (3 ea)	100-Large Fab - Basket - 1	S211134
D4034-041	Aft Upper Rib Assembly	1 pcs (1 ea)	100-Large Fab - Basket - 1	S222435
D4277-19	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	S115591
D4277-3	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	S110971
D4277-5	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	S163821
D4277-9	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	S110979
D4278-045	Rib Assembly, Fwd Cham	2 pcs (2 ea)	100-Large Fab - Basket - 1	S226594
D4278-047	Upper Rib Assembly-Straight	1 pcs (1 ea)	100-Large Fab - Basket - 1	S165029
D4279-5	End Mesh, Basket	1 pcs (1 ea)	100-Large Fab - Basket - 1	S117794
D4279-7	End Mesh, Basket	2 pcs (2 ea)	100-Large Fab - Basket - 1	S228692
D4279-9	End Mesh, Basket	1 pcs (1 ea)	100-Large Fab - Basket - 1	S087812
D4306-043	Rib Assembly, LH	1 pcs (1 ea)	100-Large Fab - Basket - 1	S017134
D4306-045	Rib Assembly	1 pcs (1 ea)	100-Large Fab - Basket - 1	S163940
D4306-1	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	S155615
D4672-1	Blanking Plate	2 pcs (2 ea)	100-Large Fab - Basket - 1	S210714
M304EX0.75-16F	Expanded Metal Flat SS	32 sf (32 ea)	100-Large Fab - Basket - 1	S210454

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	97	0
	D3913-1	1	14	0
	D3913-15	1	19	0
	D3913-3	1	8	0
	D3913-9	1	13	0
	D3916-5	3	17	0
	D4016-1	3	29	0
	D4017-7	3	43	0
	D4021-1	3	51	0
	D4034-041	1	4	0
	D4277-19	1	3	0
	D4277-3	1	3	0
	D4277-5	2	2	0
	D4277-9	1	3	0
	D4278-045	2	0	0
	D4278-047	1	1	0
	D4279-5	1	3	0
	D4279-7	2	0	0
	D4279-9	1	6	0
	D4306-043	1	1	0
	D4306-045	1	1	0
	D4306-1	1	3	0
	D4672-1	2	21	0
	M304EX0.75-16F	32	1,003	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____ **WORK ORDER NON-CONFORMANCE / ROUTE UPDATE**

Route update only ☐

NCR No. _____		DEPARTMENT/PROCESS	
Job: _____	DISPOSITION	Eng. (Non-AW)	Engineering
Part No. _____	Rework ☐	Prod. Eng. Coord.	Water Jet
	Scrap ☐	Rec/Store/Packaging	Supplier
	Use-as-is ☐	Finishing	Quality
		Skid-tube ☐	
		Machining ☐	
		Large Fab ☐	
Sequence #: _____		QTY Affected: _____	
Date: _____		MRB (QS1042)	
Description Work Order Deviation		Disposition	
		Completed By	
		Lead hand / Supervisor	
		QC / QA Coordinator	
Root Cause		FAULT CATEGORY	
Operator ☐		Positioned Wrong ☐	
Manufacturing Process ☐		Outside Tolerance ☐	
Equip/Tooling ☐		Drawing ☐	
Handling/Preservation ☐		Finish ☐	
Material ☐		Part Lost/Missing ☐	
Product Improvement ☐		Misread ☐	
Process Improvement ☐		Power Loss/Surge ☐	
Human Factors ☐		Folio/Program ☐	
		Grain Direction ☐	
		Weld ☐	
		Wrong Stock Pulled ☐	
		Out of Sequence ☐	
		Off-set/Set-up ☐	
		Contamination ☐	
		Misaligned/off center ☐	
		BOM/Route ☐	
		Broken/Damage/Defect ☐	
		Incomplete/Unclear Instructions ☐	
		Drill Holes ☐	
		Fit/Function ☐	
		Pressure/Forced ☐	
		Bending ☐	
		Crushing ☐	
		Cracks ☐	
		Crimp/Kink/Ripple/Wave/Twist ☐	
		Marks/Chatter ☐	
		Mislabeled ☐	
		Other/Details: _____	